

Amendments to the Specification

Please replace the paragraph that spans from page 7, line 29 to page 8, line 6 with the following:

FIG. 5 depicts a tapered wedge shaped end 40 of a pipe 41 which has been clad with a clad layer 43 and where further material 42 compatible with the clad layer 43 has been deposited around the end of the pipe ~~41~~ to allow further machining without exposing the base pipe 41. The inward sloping angle X of the tapered end 40 is selected such that the heated pipe ends are substantially axially aligned and the taper angle is selected such that the clad layers 43 of adjacent pipe ends touch each other first before the base pipes touch each other during a forge welding operation.